Page 1

Thursday, June 02, 2011 2:46:11 PM

Item ID:

D3204-5

Accept

Revision ID:

Item Name: Arm

Start Date: 6/8/2011 **Start Oty:** 6.00

Required Date: 6/17/2011

Req'd Oty: 6.00

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Tool ID

Cust Item ID:

Customer:

Date:

Tool # Plan

Code

Run

Setup Start

Start

Stop

Reject

Number

Stop

Reject

Otv

Accept

Otv

Stamp

Sequence ID/ Work Center ID Operation Description

Revision Nbr

Set Up/

Run Hours

Draw Nbr

D3204

Rev A1

Bandsaw

BAND SAW

Memo

0.00

0.00

Jeaspa Bandsaw

Cut blank: 1.25" x 0.375" x 3.370" long Bar (+0.030/-0.000)

HAAS 1

HAAS CNC VERTICAL MACHINING #1

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

HAAS CNC vertical machine #1

1- Machine as per Folio FA344 and Dwg D3204112- Deburr Hidentify as D3204-

120

Quality Control

Memo

0.00

Dart	Aeros	pace	Ltd
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W/O:			WC	ORK ORDER CH	ANGES						
DATE	STEP	PRO	OCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No		PAR #:	Fault Cate	gory:	NC	R: Yes N	lo DQ	A:	Date:		
	R	esolution:	Disposition	n:	QA	: N/C Clos	sed:		Date:		
NCR:			WORK ORDI	ER NON-CONFO	RMANCI	E (NCR)					
		Description of NC		Corrective Action		Section B		Verification A		Approval Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign & Date		Section C		Chief Eng	QC Inspector
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Work Order ID 70320

Thursday, June 02, 2011 2:46:11 PM

Item ID:

D3204-5

Accept

Revision ID:

Item Name: Arm

6/8/2011 Start Date:

Start Otv: 6.00

Required Date: 6/17/2011

Reg'd Otv: 6.00

Reference:

Approvals:

Process Plan:

OC:

Date: Date: **Tooling:**

SPC (Y/N):

Tool ID

Cust Item ID:

Customer:

Date:

Date:

Run

Stop

Start

Setup Start

Stop

Number Stamp

Sequence ID/ Work Center ID

130

Ouality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ Run Hours

0.00

0.00

11/06/09

Tool # Plan

Code

Accept

Otv

Otv

Reject

140

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

Memo

QC21- Final Inspection - Work Order Release

Quality Control

150

Memo

0.00

Reject

MF 11-06-10

0.00

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W/O:			WO	RK ORDER CH	ANGES					
DATE	STEP	PRO	OCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	R	esolution:							Date: _ 	
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DATE	STEP	Description of NC	Corrective Action		Section B		Verification		Approval	Approval
DATE	JIEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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Picklist Print

Thursday, June 02, 2011 2:46:08 PM

Work Order ID: 70320

Parent Item:

D3204-5

Parent Item Name: Arm



Comments:

IPP: [IC] | 05.08.11 | Added Step 25 | KJ/JLM | +

Component Item ID/ Item Name

Item ID

Replacement Mfg/ Purch Bin Primary Item Location

Last Location

M6061T6B0.375X01.25

Purchased

No



6061-T6 Bar .375 x 1.25

Location

MAT002

110167

110908

Start Date: 6/8/2011

Required Date: 6/17/2011

Start Qty: 6.00

Required Oty: 6.00

Route Seq ID	Unit of Measure		Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
100	f	22.0000	0.2913	1 83978	9		



Loc Qty Loc Code 22 10 12

1.8398 cm/1/06/09

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		Description of NC		Corrective Action	Section B Verification			ation	Approval Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign & Date		on C	Chief Eng	QC Inspector
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Description: Arm	Part Number: D3	204-5
	<i>y</i>	
Inspection Dwg: D3204 Rev: A1	Page	1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		X First Arti	cle	Prot	otype	
Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	iolerance	Dimension	Accept	Reject	Inspection	Comments

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.375	+/-0.010	R.375			Vern ML-7	
0.750	+/-0.010	.750	/		11	
R0.50	+/-0.030	P.500			11	
R0.500	+/-0.010	R.500			7.	
Ø0.760	+0.005/-0.000	\$.760	_/		11	
0.080	+/-0.010	078			it	,
2.373	+/-0.005	2370	-		, .	j
Ø0.375	+0.005/-0.000	Ø.374			,(
0.250	+/-0.010	.250	_		Y	
R0.06	+/-0.030	R.060	_		٠,(
0.200	+/-0.010	.200			١٠,	
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Measured by:	Crol	Audited by:	BB	Prototype Approval:	N/A
Date:	11/06/09	Date:	11/00/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	05.02.17	New Issue	KJ/JLM	1
В	06.03.21	Dwg Rev update	KJ/JLM	Gill

Dart Ae	rospace	Ltd							
W/O:				WO	RK ORDER CHANGE	S			
DATE	STEP	PROCEDUR		E CHANGE		Ву	Date Q	ty Approval Chief Eng / Prod Mgr	Approva QC Inspector
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									2
Part No: PAR #: F		Faul	ult Category: NC			No DQA :_	Date: _		
	Re	solution:	Disp	ositior	n:	QA: N/C C	losed:	Date: _	
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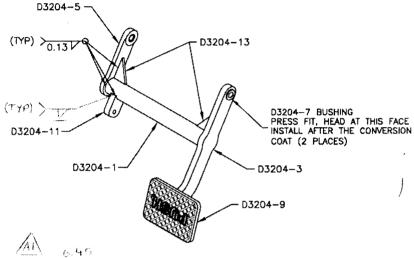
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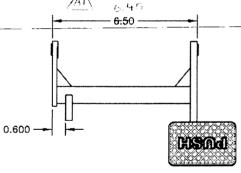




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	DATE			TITLE	SCALE
	04.0	1.27		RELEASE PEDAL ASSEMBLY	NTS
	Α	.1	04.01.27	NEW ISSUE	

05 07.15 6.45 WAS 6.50







D3204-041 RELEASE PEDAL ASSEMBLY

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B) 4) MATERIAL: AISI 303 SS (M303R)

- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
 ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
 7) WELD ASSEMBLY PER QSI 004
 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 11) ALL DIMENSIONS ARE INCHES

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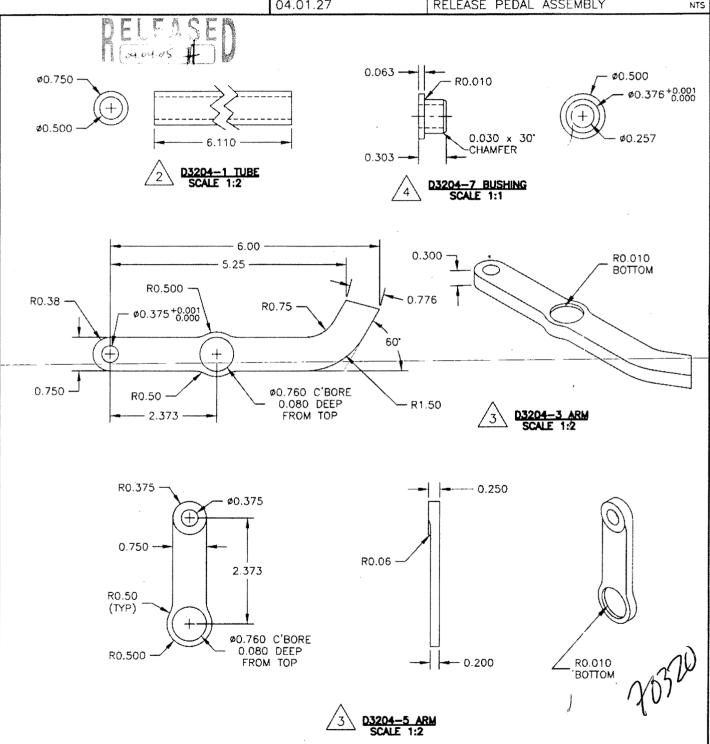
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Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval **Approval** PROCEDURE CHANGE DATE STFP Bv Date Qtv Chief Eng / QC Inspector Prod Mar Part No: PAR #: Fault Category: NCR: Yes No DQA: ____ Date: _____ Resolution: QA: N/C Closed: _____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Verification **Description of NC Approval** Approval DATE **STEP** Sian & Initial **Action Description** QC Inspector Section A Section C Chief Ena Chief Eng Date Chief Eng





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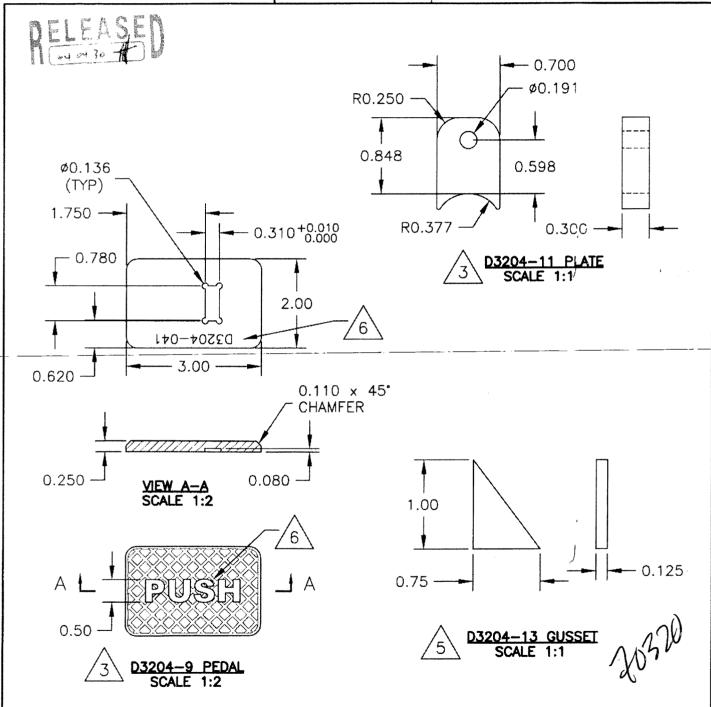
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